

Work Order ID 67685

Tuesday, March 29, 2011 11:24:11 AM



Page 1

Item ID: D206-642-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 11/03/29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D206-642

Rev N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

S 11/05/14

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

JB PD

11/04/27

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

@

13671.54

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67685

Tuesday, March 29, 2011 11:24:12 AM



Page 2

Item ID: D206-642-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-311 Location: <u>82</u> PPP Rev: _____								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/5/12

ME
11-05-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 11:24:18 AM

Page 1

Work Order ID: 67685

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC
IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M
as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-642-341

Manufactured

No

110

Each

3.0000

1

1



Replacement Skidtube

Location

Loc Qty

Loc Code

FG082

3

36550

1

44043

1

44044

1

D206-648-013

Manufactured

No

110

Each

4.0000

1

1



GHW Modification

Location

Loc Qty

Loc Code

FG120

4

67296

4

D2932-1

Manufactured

No

110

Each

0.0000

1

1



Saddle LH Out, 206

D2933-1

Manufactured

No

110

Each

2.0000

1

1



Saddle LH In, 206

Location

Loc Qty

Loc Code

ST421

2

66398

2

67154 *Purifier*

B67297 *JB* *D*

B67790 *JB* *sl*

B67791 *JB* *11/04/27*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 11:24:18 AM

Page 2

Work Order ID: 67685

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2938-1

Manufactured No

110 Each

5.0000

1

1

✓



Saddle LH Out, 206



JB

Location

Loc Qty

Loc Code

ST421

2

66399

2

ST428A

3

66251

3

Manufactured No

110 Each

1.0000

1

1

✓

D2939-1



Saddle LH In, 206



66251

B 67674

JB

Location

Loc Qty

Loc Code

ST421

1

66400

1

Purchased No

110 Each

368.0000

8

8

✓

AN3-41A



Bolt



JB 11/04/27

Location

Loc Qty

Loc Code

ST354

369

112431

1

114941

68

115936

100

116191

200

114941

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 11:24:19 AM

Page 3

Work Order ID: 67685

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2652

Manufactured No

110 Each

364.0000

16

16 ✓

Bushing

Location

Loc Qty

Loc Code

FG	44
31985	44
ST019	320
65049	32
66124	121
66934	167

66124 x 5
66934 x 11
81 ✓

MS21042L3

Purchased No

110 Each

2,189.000

8

Nut

Location

Loc Qty

Loc Code

ST300	2189
116391	589
116540	800
116549	800

116540

AN960JD10

NAS1149D0363J

Purchased No

110 Each

0.0000

8

8 ✓

Washer

AN5-10A

Purchased No

110 Each

152.0000

14

14 ✓

Bolt

Location

Loc Qty

Loc Code

ST337	152
115700	2
116704	50
116924	50
117010	50

117010

Tuesday, March 29, 2011 11:24:19 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 11:24:19 AM

Page 4

Work Order ID: 67685

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-11A

Purchased

No

110

Each

61.0000

4

4

Bolt

Location

Loc Qty

Loc Code

ST337

61

115422

6

116419

25

116978

30

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

0.0000

8

18

Washer

AN4-6A

Purchased

No

110

Each

1,079.000

12

12

Bolt

Location

Loc Qty

Loc Code

ST356

1079

115936

200

116191

79

116400

400

116924

400

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

0.0000

25

25

Washer

MS21042L4

Purchased

No

110

Each

3,324.000

12

12

Nut

Location

Loc Qty

Loc Code

ST300

3324

116188

1324

116823

2000

Tuesday, March 29, 2011 11:24:20 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 11:24:20 AM

Page 5

Work Order ID: 67685

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

1.0000

1

1 ✓

Tow Ring

Location

Loc Qty

Loc Code

ST420

6

66386

6

ST464

1

64071

1

D3456-1

Manufactured No

110 Each

62.0000

1

1 ✓

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

55

64282

5

66848

50

D3457-1

Manufactured No

110 Each

24.0000

2

2 ✓

Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

14

66030

14

Tuesday, March 29, 2011 11:24:20 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 11:24:20 AM

Page 6

Work Order ID: 67685

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

737.0000

1

1

✓



Nut



JB SP

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

697

116188

397

116549

300

116188

AN4C5A

Purchased

No

110

Each

544.0000

1

1

✓



BOLT



JB SP

Location

Loc Qty

Loc Code

FP-B

117

112243

117

ST345

427

112243

427

112243

AN960C416

NAS1149C0463

Purchased

No

110

Each

0.0000

1

1

✓



washer

D3413-1

Manufactured

No

110

Each

48.0000

1

1

✓



Ring



M 116900 JB

JB 11/04/27

Location

Loc Qty

Loc Code

ST420

22

62961

8

66387

14

ST473

26

53446

1

65294

10

66945

15

65387

65294

Tuesday, March 29, 2011 11:24:20 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 11:24:20 AM

Page 7

Work Order ID: 67685

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2712

Manufactured No

110 Each

571.0000 10 10 ✓

Set Screw

Location

Loc Qty

Loc Code

FG	50	
29962	50	
ST012	252	
66955	252	
ST021	269	
61331	19	
65115	250	

D2934

Manufactured No

110 Each

21.0000 2 2 ✓

Saddle Spacer

Location

Loc Qty

Loc Code

FG	6	
31929	6	
ST027	15	
66043	15	

D2935

Manufactured No

110 Each

80.0000 2 2 ✓

Saddle Spacer

Location

Loc Qty

Loc Code

ST027	80	
63558	9	
66564	71	

Tuesday, March 29, 2011 11:24:20 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

• COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: N
Date: 09.09.09

